

# Work Order ID 67951

Tuesday, April 05, 2011 7:52:03 AM



Page 1

Item ID:	D3186-2M	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	SPACEPOD DOOR RH					
Start Date:	4/5/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/6/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/04/05</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3186	Rev E

100		0.00							
	PURCHASING								<u>CL 11/04/05 (1)</u>
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>P/O 13797</u>								
	Description: D3186-2MDoor								
	Supplier: Delastek								
	Conformity Certificate and Process sheet required								
	Ship 3 Items from Previous steps								

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								<u>P 11/6/13 (1)</u>
Packaging	Memo	0.00							
Packaging	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67951**

Tuesday, April 05, 2011 7:52:03 AM



Page 2

Item ID: D3186-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8 w/06/12

Quality Control

Check for void spot and pins.

130

Identify as per dwg & Stock Location: composites 0.00

Packaging

Memo

0.00

RT 11-06-21 (x)

Packaging

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

11/6/21

Quality Control

ME 11-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 05, 2011 7:52:00 AM

Page 1

Work Order ID: 67951



Parent Item: D3186-2M



Parent Item Name: SPACEPOD DOOR RH


Start Date: 4/5/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec  
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P  Spacepod Door		Purchased	No			110	Each	0.0000	1	1			

367951



4/6/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

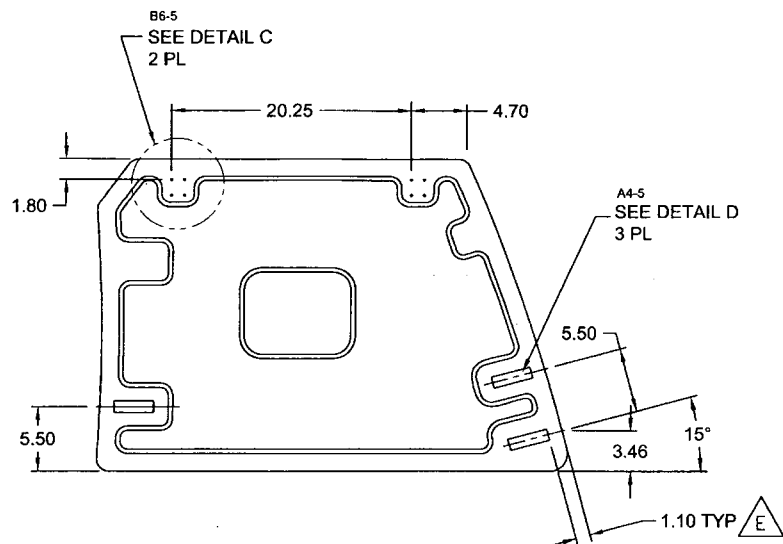
8 7 6 5 4 3 2 1

D

C

B

A

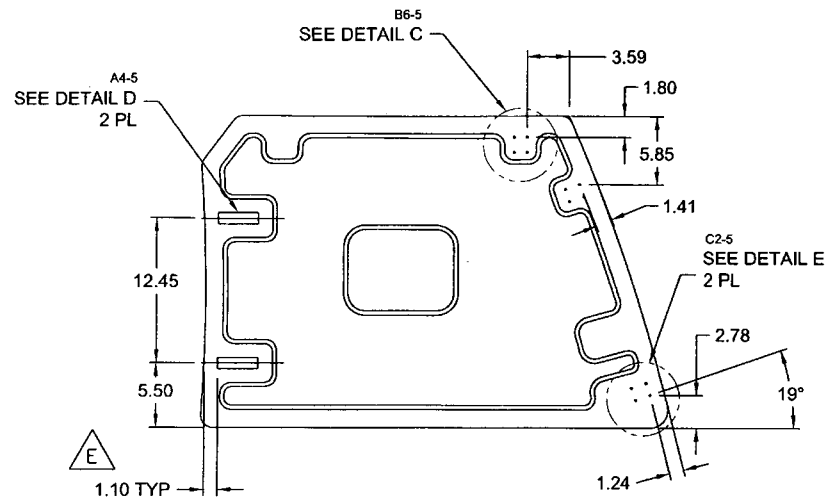


**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

C/L 11/04/05  
W10: 67951



**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**RELEASED**  
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

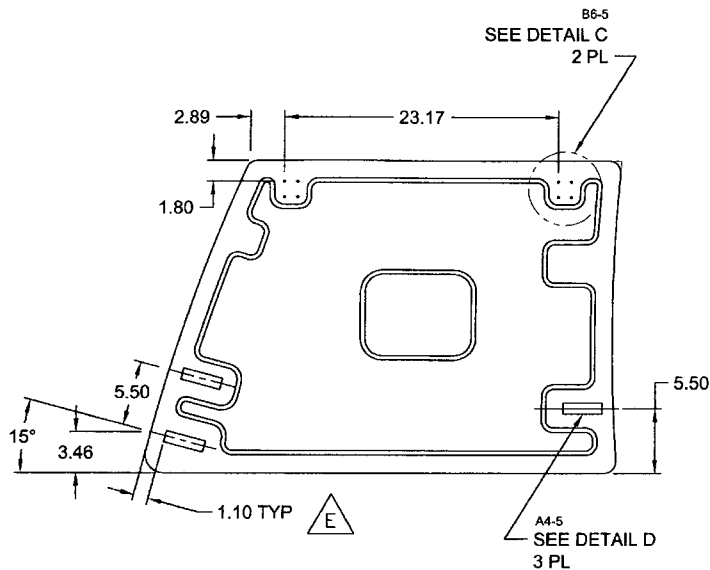
A

D

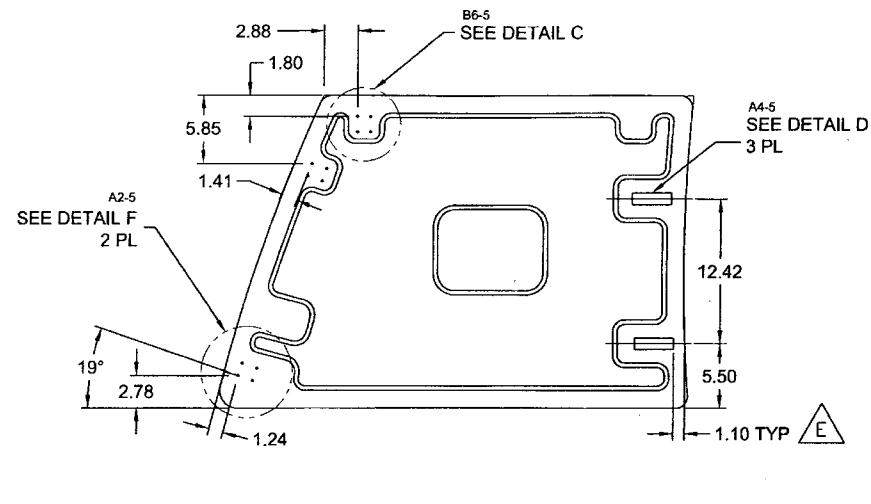
C

B

A



**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M



**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

**RELEASED**  
2009-09-09

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

W10.67951

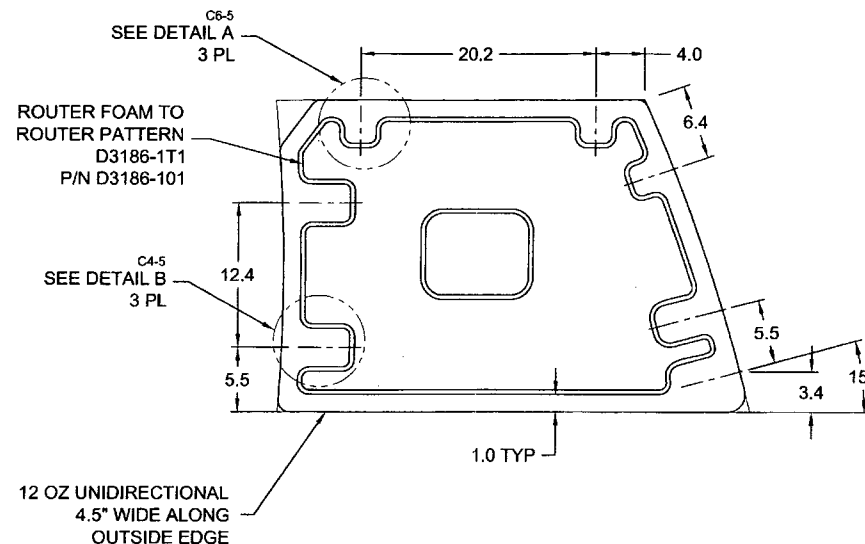
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



# MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



**D3186-1M SPACEPOD DOOR AS MOLDED**

## NOTES:

### 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

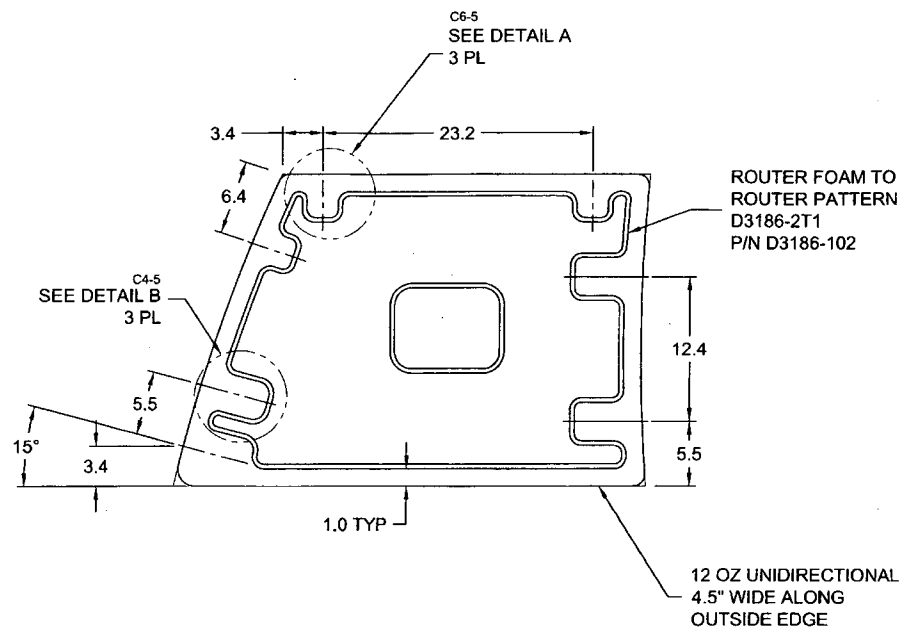
8) USE MOLD DT8005 FOR DOOR LAYUP

**RELEASED**  
2009-08-08

W10:67951

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



NOTES:  
1) MATERIAL:

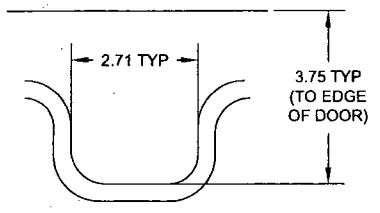
- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 7.0 lbs  
8) USE MOLD DT8006 FOR DOOR LAYOUT

**D3186-2M SPACEPOD DOOR AS MOLDED**

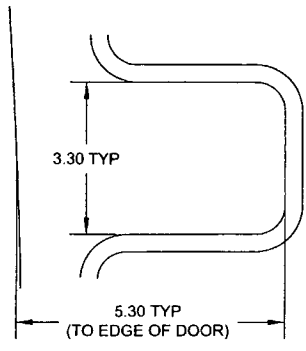
RELEASED  
2009-09-09

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. D3186  TITLE SPACEPOD DOOR  COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT OR ITS CONTENTS ARE IN FULL OR IN PART THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OF COMMUNICATIONS TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. E
DRAWN	RF		SHEET 4 OF 5
CHECKED	CP		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		SCALE
DE APPR.	<i>[Signature]</i>		NTS
DATE	09.07.08		

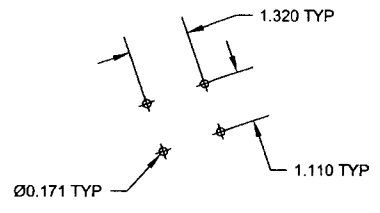
8 7 6 5 4 3 2 1



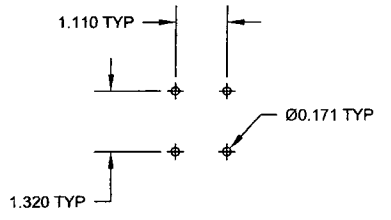
**DETAIL A**  
SCALE 4X  
D6-3  
D4-4



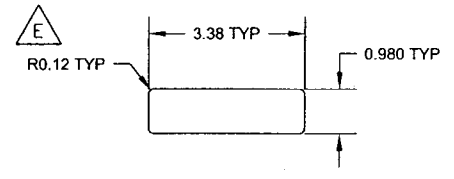
**DETAIL B**  
SCALE 4X  
C6-3  
C6-4



**DETAIL E**  
SCALE 4X  
C1-1

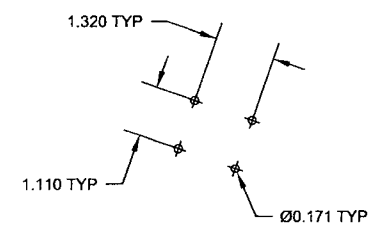


**DETAIL C**  
SCALE 4X  
D7-1  
D3-1  
D6-2  
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR




**DETAIL D**  
SCALE 4X  
C5-1  
D4-1  
B6-2  
C2-2



**DETAIL F**  
SCALE 4X  
C4-2

**RELEASED**  
2009-09-09

W10167951

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO13797

Purchase Order Date 4/5/2011

PO Print Date 4/5/2011

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC

2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7  
CA

Contact Name

Vendor Phone

819 533 5788

Vendor Fax

819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

PAID  
EX 11/04/05

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D3186-2P		Spacepod Door	5/6/2011 Yes	1.00 Each	Purolator ground	\$711.0000	\$711.00
		Special Inst:	AS PER DWG D3186 REV. E B67951				
D3188-2P		Spacepod Body	5/6/2011 Yes	1.00 Each	Purolator ground	\$2,177.0000	\$2,177.00
		Special Inst:	AS PER DWG D3188 REV. F B67950				

PO Total:

\$2,888.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 4/5/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	38835
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson			
EPIC EXPRESS COLLECT		Origin		Net 30 days USA		Claude Lessard, ext. 233			
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #			
09/06/2011	07/04/2011	17271	Chantal Lavoie	PO13797					
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description					
1	0	1	DKC134-0060	Line 1 N° D31862P Spacepod Door RH B67951 U de M : Each Dwg. Rév.: E <u>No. série</u> B67951 <u>No. lot</u> 32793 8 w/lot 137					

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mardi, 2011-04-19 07:38:07  
 Utilisateur: Pascal Carignan

**Feuille de Procédé**

<b>Client</b> :	DART US DART AEROSPACE LTD		<b>Nom Dessin</b> :	SPACEPOD DOOR RH	
<b>Numéro Job</b> :	32793		<b>Numéro Article</b> :	DKC134-0060	
<b>Numéro Soumission</b> :	3769		<b>Numéro Dessin</b> :	D3186	
<b>Numéro B.A.</b> :			<b>Projet Numéro</b> :	DK-359	
<b>Cette fois</b> :	2011-04-19	<b>No. B.V.</b> :	<b>Révision dessin</b> :	E	
<b>Prsht Rev.</b> :	NC		<b>Matériel</b> :	7781 & 411-350	
<b>Prem. fois</b> :	--	<b>Type</b> :	<b>Date Dûe</b> :	2011-04-26	<b>Qté:</b> 1 Udm: UNITE
<b>Job précédente</b> :	32792				
<b>Écrit par</b> :					
<b>Vérifié &amp; Approuvé par</b> :					
<b>Commentaires</b> :	N° de pièce Client: D31862M				

**B 67951**

Process Sheet Rév.: 01 changer le sikkens AAC1390 pour le P15-3  
 (AAC1492), enlever le AAC1617, changer le frekote 44-NC pour le  
 Wolo

**Produit additionnel**

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
<b>Commentair</b> Qty.:	0.050 UNITE(s)/Unit	Total : 0.050 UNITE(s)
	N° 83634, Frekote Loctite Wolo	# de Lot: _____

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



**Commentair** Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0	AC0883	Tissu à délaminer Release ply B
<b>Commentair</b> Qty.:	3.28 VERGE(s)/Unit	Total : 3.28 VERGE(s)
4.0	AC0884	Wrightlon 5200 Bleu P3
<b>Commentair</b> Qty.:	3.59 VERGE(s)/Unit	Total : 3.59 VERGE(s)
5.0	AC0885	Feutre de drainage N° Airweave N 10
<b>Commentair</b> Qty.:	3.00 VERGE(s)/Unit	Total : 3.00 VERGE(s)
6.0	AC0943	Stretchlon 200 poche à vide Vert
<b>Commentair</b> Qty.:	3.00 VERGE(s)/Unit	Total : 3.00 VERGE(s)
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
<b>Commentair</b> Qty.:	4.5 VERGE(s)/Unit	Total : 4.5 VERGE(s)
	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	N° de Lot: <b>1-30234-1</b>

Date: Mardi, 2011-04-19 07:38:07

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 32793

Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentaire Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)

9.0	AMB0349	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentaire Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22945-1

10.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe.

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 29/04/11

Sceau:



11.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-30828-4

13.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 17-5-11

Sceau:



14.0	LAMINAGE	Faire le laminage
------	----------	-------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 17-5-11

Sceau:



Date: Mardi, 2011-04-19 07:38:08

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 32793

Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

15.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 2:30

Heure Fin Curing: 11:00

Date: 17-5-11

Sceau:



16.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0120 GALLON(s)/Unit Total: 0.0120 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total: 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-30549-1

18.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbibier toutes les surfaces du Foam Core selon IG0105.

Date: 2-5-11

Sceau:



19.0

DKC134-0057

Foam Core N° D3186-102 ( Porte D3186-2 )

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Foam Core N° D3186-102 ( Porte D3186-2 )

N° de Job:

32817

20.0

AAC1611

Polybond B46F

Commentair Qty.: 0.090 KIT(s)/Unit Total: 0.090 KIT(s)

Polybond B46F

N° de Lot:

1-27795-1

21.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )



Date: Mardi, 2011-04-19 07:38:08

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 32793

Numéro Article: DKC134-0060

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 20-5-11 Sceau:



22.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

- Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10:55

Heure Fin Curing: 12:30

Date: 20-5-11 Sceau:



23.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-31015-1

25.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 30-5-11 Sceau:



A.M.

26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 30-5-11 Sceau:



A.M.

Date: Mardi, 2011-04-19 07:38:08

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 32793

Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

27.0	BAGGING	Faire le bagging sur la pièce
------	---------	-------------------------------




Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 1:10 Heure Fin Curing: 8:00

Date: 30-5-11 Sceau:  A.M.

28.0	DÉMOULAGE	Démoulage de la pièce
------	-----------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 1-6-11 Sceau: 

29.0	TRIMAGE	Trimage
------	---------	---------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 2-6-11 Sceau: 

30.0	AAC1021	Dupont Primer N° 7704S
------	---------	------------------------

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-28961-2

31.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
------	---------	---

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-29932-3

32.0	PRIMER	Application primer
------	--------	--------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 3 juin 2011 Sceau:  # de fiche de mélange: N/A